

Date: Thursday, 7/13/2006 3:24:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 27887		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/13/2006 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 8/9/2006		
Previous Run	: 27761		Qty:	16	Um:	Each
Written By	: <i>Seq. Comment Below</i>		Comment			
Checked & Approved By	: <i>BJ 06.07.13 w</i>		Comment			
: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101007	7075-T7351 8.25X7.75X2.5		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <i>BS23941 x 16</i>				
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>327887</i> Double check by: <i>J.L.</i> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <i>J.G for 06/07/01 16</i>				
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 <i>J.G for 06/07/01 16</i>				
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.G for 06/07/01 16</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 06/07/27

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 7/13/2006 3:24:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27887

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

9/1 06/07/23 16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

PL 06/07/24 16

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25 ⑯

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10/6/26 ⑯

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ASST 358*

PL 6/7/26 ⑯

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PL 06/07/27 ⑯

Job Completion



PL 06.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD				Work Order: 27887	
Description: Saddle, Fwd Outboard				Part Number: D2571	
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.747	1.746	1.746		
C	3.495	3.505		3.499	3.498	3.497	3.496		
D	1.745	1.755		1.748	1.746	1.747	1.746		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		0.498	0.497	0.498	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.499	0.498	0.498	0.499		
J	1.174	1.184		1.180	1.179	1.180	1.178		
K	0.558	0.578		0.569	0.569	0.568	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.501	1.501	1.500	1.501		
N	2.495	2.505		2.499	2.498	2.497	2.496		
O	3.869	3.879		3.871	3.873	3.872	3.871		
P	0.115	0.135		0.120	0.120	0.121	0.122		
Q	0.115	0.135		0.131	0.133	0.130	0.130		
R	0.240	0.260		0.241	0.243	0.241	0.240		
S	0.115	0.135		0.125	0.124	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.962	2.961	2.960		
V	0.230	0.250		0.237	0.236	0.236	0.237		
W	0.115	0.135		0.124	0.123	0.124	0.127		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.363	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.621	0.621	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.244	0.245		
AE	1.375	1.395		1.388	1.386	1.386	1.387		
AF	0.115	0.135		0.135	0.134	0.135	0.134		
AG	0.240	0.280		0.259	0.258	0.237	0.236		
AH	0.240	0.260		0.252	0.254	0.254	0.254		
AI	2.000	2.020		2.001	2.000	2.001	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	3.G	Audited by:	gml
Date:	06/07/17	Date:	06/07/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	gml

DART AEROSPACE LTD.				Work Order:	27887
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.745	1.747	1.745		
C	3.495	3.505		3.495	3.498	3.498	3.496		
D	1.745	1.755		1.745	1.745	1.747	1.745		
E	7.990	8.010		8.002	8.001	8.001	8.002		
F	0.490	0.510		0.497	0.497	0.499	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.498	0.496	0.497		
J	1.174	1.184		1.178	1.178	1.179	1.178		
K	0.558	0.578		0.560	0.564	0.564	0.563		
L	1.174	1.184		1.178	1.178	1.179	1.178		
M	1.490	1.500		1.491	1.492	1.493	1.494		
N	2.495	2.505		2.498	2.497	2.498	2.496		
O	3.869	3.879		3.872	3.871	3.874	3.872		
P	0.115	0.135		0.126	0.124	0.127	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.250	0.253	0.250		
S	0.115	0.135		0.127	0.127	0.125	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.238	0.236	0.240		
W	0.115	0.135		0.126	0.124	0.120	0.120		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.360	0.360	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.626	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.248	0.247	0.245		
AE	1.375	1.395		1.384	1.385	1.382	1.383		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.246	0.250	0.247		
AI	2.000	2.020		2.000	2.001	2.001	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	3.G/EP	Audited by:	EW
Date:	06/07/19	Date:	06/10/2013

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i>	<i>JK</i>

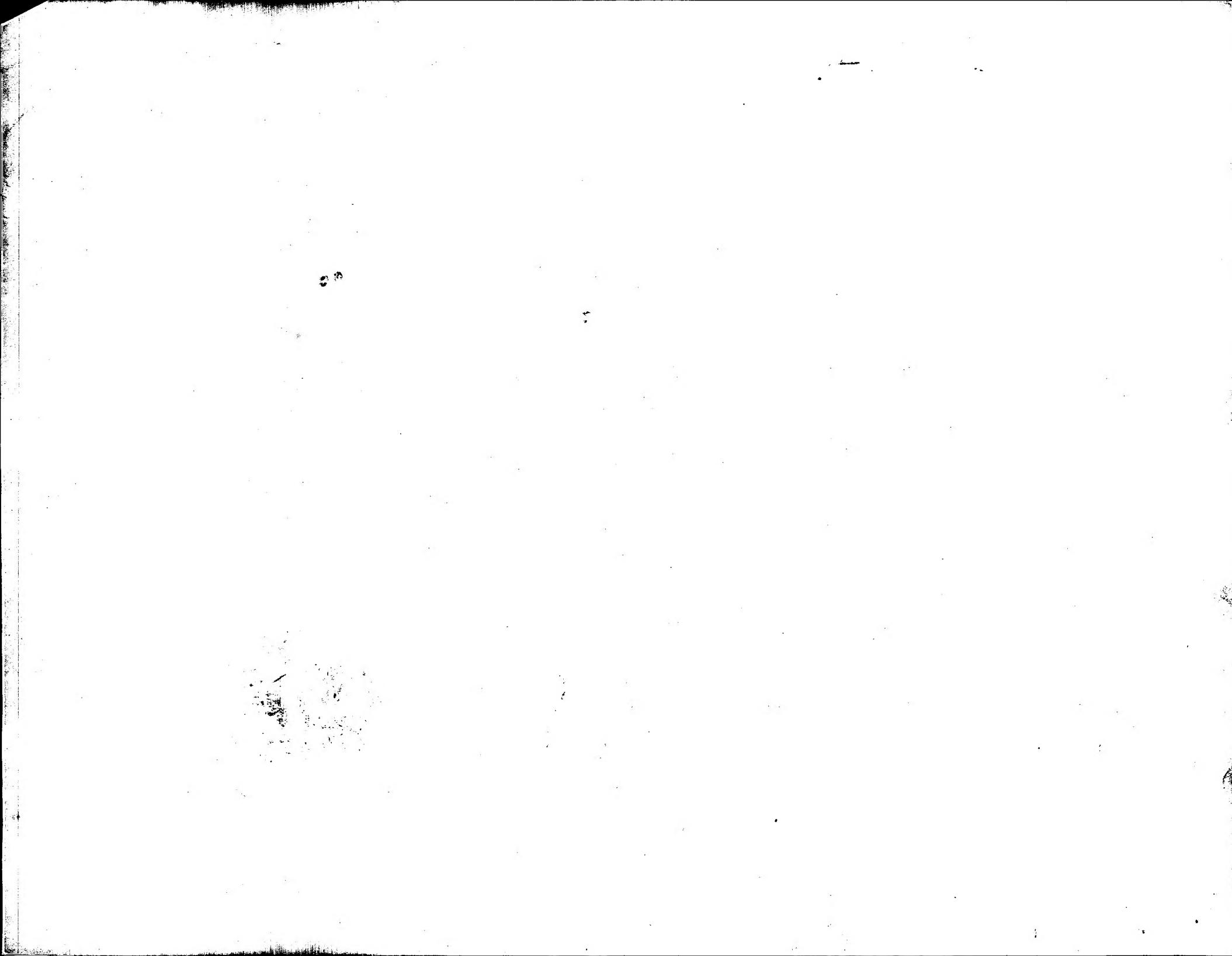
DART AEROSPACE LTD				Work Order: 27887	
Description: Saddle, Fwd Outboard				Part Number: D2571	
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.756	1.747	1.746		
C	3.495	3.505		3.497	3.497	3.498	3.497		
D	1.745	1.755		1.745	1.750	1.747	1.747		
E	7.990	8.010		8.003	8.001	8.002	8.000		
F	0.490	0.510		0.497	0.498	0.499	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.497	0.495	0.496	0.497		
J	1.174	1.184		1.176	1.177	1.179	1.179		
K	0.558	0.578		0.564	0.564	0.564	0.564		
L	1.174	1.184		1.176	1.172	1.177	1.178		
M	1.490	1.500		1.494	1.495	1.496	1.497		
N	2.495	2.505		2.495	2.496	2.497	2.496		
O	3.869	3.879		3.872	3.875	3.874	3.873		
P	0.115	0.135		0.124	0.126	0.125	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.253	0.254	0.254		
S	0.115	0.135		0.123	0.127	0.126	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.242	0.239	0.239	0.239		
W	0.115	0.135		0.122	0.120	0.121	0.122		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.370	0.369	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.624	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.247	0.246		
AE	1.375	1.395		1.385	1.386	1.386	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.250	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	E.P. 15.G	Audited by:	7/7
Date:	06/07/2020	Date:	06/07/2020

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	7/7



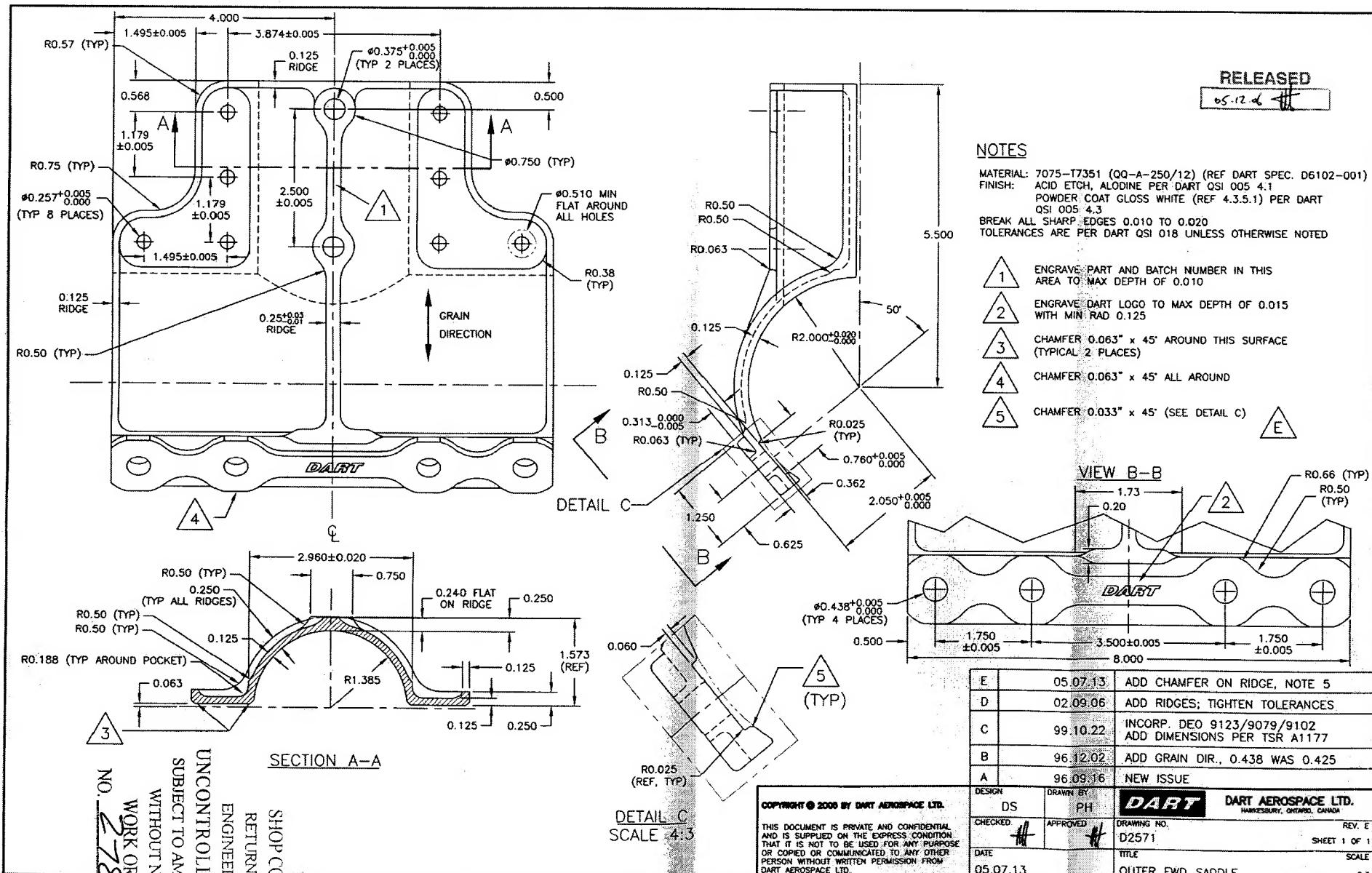
DART AEROSPACE LTD				Work Order:	27887
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

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L	1.174	1.184		1.179	1.178	1.180	1.179		
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P	0.115	0.135		0.122	0.123	0.124	0.123		
Q	0.115	0.135		0.130	0.128	0.127	0.126		
R	0.240	0.260		0.247	0.248	0.247	0.246		
S	0.115	0.135		0.128	0.127	0.126	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.962	2.961	2.960		
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AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.625	0.621	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.253	0.254		
AE	1.375	1.395		1.386	1.388	1.385	1.384		
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AH	0.240	0.260		0.249	0.248	0.247	0.246		
AI	2.000	2.020		2.001	2.000	2.000	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J. G.	Audited by:	J. M.
Date:	06/07/21	Date:	06/07/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	J. M. J. L. M.



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 27887
SHOP COPY
RETURN TO
ENGINEERING